

Work Order ID 130737

Tuesday, March 24, 2015 1:30:06 PM

130737

Page 1

Item ID: D412-711-101

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Vertical Reference Window

Start Date: 3/24/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 3/24/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MS

Date: 15-03-24 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D412-711-101	B
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100	Document Control
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0.00

DAS
6
9-89

MS

100

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefiles and create labels
for PPP D412-711-101 Change 002

110

0.00

110

HandThermo

HAND FINISHING THERMOFORMING

Memo

0.00

Hand Finishing Thermoforming

Set up Machine as per folio FTA 077 and D711W program using mould DT9640

B 15/04/13

120

0.00

120

HandThermo

HAND FINISHING THERMOFORMING

Memo

0.00

Hand Finishing Thermoforming

Cut Blanks to 37.5" by 43"

B 15/04/13

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Start Date: 3/24/2015 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 3/24/2015 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00

130

THERMOFORMING MACHINE

Thermoform

Memo

0.00

Thermoforming Machine

Thermoform as per Dwg. D412-711-101 using DT 9640 and Folio FTA 077

Dwg. Rev. B

Folio Rev. B

Visually inspect for proper formation and clarity

Visually ~~and inspect~~ magic eye

Verified by: B

B 15/04/13

160

0.00

160

HAND FINISHING THERMOFORMING

HandThermo

Memo

0.00

Hand Finishing Thermoforming

1) Trim off excess flange material
2) Buff out any light scratches or
3) Etch part number and batch number
blemishes

B 15/04/13

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Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Replacement Vertical Reference Window

Start Date: 3/24/2015 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 3/24/2015 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start *NR1*

QC: Date: SPC (Y/N): Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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170

QC2- Inspect parts off machine FAI/FAIB

0.00

170

QC

Memo

0.00

Quality Control

1) Visually inspect for clarity, and proper formation.

15/04/15

180

QC5- Inspect part completeness to step on W/O

0.00

180

QC

Memo

0.00

Quality Control

1) Visually inspect for clarity, and proper formation.

1

15-04-20

185

QC4- 100% Inspect kits for completeness

0.00

185

QC

Memo

0.00

Quality Control

1x

DAS
46
9-89

APR 22 2015

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Tuesday, March 24, 2015 1:30:06 PM

Item ID: D412-711-101

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Vertical Reference Window

Start Date: 3/24/2015 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 3/24/2015 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: <u>F6107</u>	0.00							
190									
Packaging	Memo	0.00							
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.00							
Quality Control									

(10)

DAS

46

APR 22 2015

9-80

MLJ 15-04-23

MF

15-4-23

Picklist Print

Tuesday, March 24, 2015 1:30:11 PM

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Work Order ID: 130737

130737

Parent Item: D412-711-101

D412-711-101

Parent Item Name: Replacement Vertical Reference Window

Start Date: 3/24/2015

Required Date: 3/24/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 06-02-01 JLM
Manufacture in-house 10/06/28 DL

IPP Rev. B.

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MACRLICS.236

Purchased

No

sf

289.0000

22

**

22

15/04/13

MACRI ICS 236

Plexiglass G 60" x 96"x .236"

Location

Loc Qty

Loc Code

therm

289

M129447

14

M131524

275

DART AEROSPACE LTD		Work Order: 130737
Description: Replacement Window		Part Number: D412-711-101
Inspection Dwg: D412-711-101	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST
THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____"	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: JB Date: 15/04/13

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.00	+/-0.030	2.03	✓		Ruler	
1.98 N/A	+/-0.030	?			Ruler	
1.50	Min	1.6	✓		Ruler	
0.090	Min	.099	✓		Ultra	
0.070	Min	.091	✓		" "	
0.050	Min	.076	✓		" "	
15.0	+/-0.5	14.875	✓		TH-05	

Measured by: JB Date: 15/04/13

Audited by: JB Date: 15-04-20

Preliminary Approval: _____ Date: _____

Rev	Date	Change	Revised by	Approved
B	10.10.08	New Issue	KJ	
C	13.06.03	Dimensions updated per Dwg Rev B	KJ	

